	Work Order ID 63579  Thursday, November 04, 2010 1:08:41 PM										Page 1
Item ID: Revision ID:	D3536-35			Accept		s	etup Sta	rt			
	Gasket			'	• •	**			Sto	P	
Start Date: Required Date: Reference:		tart Qty: 16.00 Req'd Qty: 16.00	1100	1	Cust Item I	ID:				1 18811181	
Approvals:	Process Plan:	W	Date: 10	11-04 Tooling:	D	 ate:		R	tun Sta	rt	
	QC:	77	Date:	SPC (Y/N):		ate:			Sto	P	
Sequence ID/ Work Center ID		peration escription		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revisio	on Nbr									
D3536	Rev A										
Waterjet FLOW CNC Waterje		OW WATER JET  Memo  1-Cut as per  Deburr if ne	Dwg D3536 [cessary	0.00 0.00 Dwg Rev: <b>A</b> □Prog Rev:_	<b>A</b> E/2-			iB.(	<u> </u>	(H	1
110	Q	C2- Inspect parts off m	achine FAI/FAIB	0.00							
QC .		Memo		0.00				HB 10	0-11-16		

Memo

Quality Control

QC8- Inspect parts - second check

Quality Control

120

Memo

Dart Aei	rospace	Lia							
W/O:			WO	RK ORDER CHANG	ES	· · · · · · · · · · · · · · · · · · ·			*
DATE	STEP	PRO	OCEDURE CHAN	NGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No	:	PAR #:	Fault Categ	gory:	_ NCR: Yes	No <b>DQ</b>	A:	Date: _	
Resolution:			Disposition	n:	_ QA: N/C CI	osed:		Date: _	
NCR:			WORK ORDE	R NON-CONFORMA	ANCE (NCF	R)			
		Description of NC	Corrective Action		Section B Ve		cation	Approval	Approval
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign 8 Date		Section C		QC Inspector
							<u></u>		

### Work Order ID 63579

Thursday, November 04, 2010 1:08:41 PM



Page 2

Item ID:

D3536-35

Accept

Setup Start



**Revision ID:** 

**Start Date:** 

Gasket Item Name:

11/4/2010 **Start Qty:** 16.00

Req'd Qty: 16.00



**Cust Item ID: Customer:** 

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Run

Qty

Start

Stop



**Required Date:** 11/12/2010

QC:

Date:

SPC (Y/N):

Date:

Date:

Stop

Sequence ID/ **Work Center ID** 

130

Packaging

Packaging

140

**Operation** Description

Identify as per dwg & Stock Location:

Memo

Set Up/ **Run Hours** 

0.00

0.00

Tool ID

Tool # Plan Code

Accept Qty

Reject Reject Number

Insp. Stamp

QC21- Final Inspection - Work Order Release

0.00



QC Quality Control

Memo

0.00

Duit Moi	oopaoc	Liu							
W/O:			WC	RK ORDER CHANG	iES				· · ·
DATE	STEP	PRO	OCEDURE CHAI	NGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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DATE	STEP	Description of NC Section A	Corrective Action Initial Action Descrip Chief Eng Chief Eng		tion B Sign Date			Approval Chief Eng	Approval QC Inspector
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## **Picklist Print**

Thursday, November 04, 2010 1:08:45 PM

Work Order ID: 63579

Parent Item:

D3536-35

Parent Item Name: Gasket



**Start Date:** 11/4/2010

**Required Dats**: 11/12/2010

Page 1

**Start Qty: 16.00** 

Required Qty: 16.00

Comments:

IPP Rev:A

New Issue 07-02-14 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MNEO60S.063		Purchased	No			100	sf	495.6220	0.6197	11.01689			
											1B10-11-	- 16	

NEOPRENE SHEET 0.063

Location		Loc Oty	Loc Code	
MAT		495.622		
	115500	95.622		115500
	115916	400		

W/O:		WORK ORDER CHANGES											
DATE	STEP	PRO	CEDURE CH	IANGE	Ву		Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector			
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		·											
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Part No:		PAR #:	Fault Category: NC			NCR: Yes No DQA: Dat							
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NCR:		W	ORK OR	DER NON-CONFORM	ANCE (N	CR)							
DATE	STEP	Description of NC Section A	Initial	Action Description		ın &	& Section C		Approval Chief Eng	Approval QC Inspector			
			Chief Eng	Chief Eng	D	ate							
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DART ALROSPACE LTD	Work Order:	63579
Description: Gasket	Part Number:	D3536-35
Inspection Dwg: D3536 Rev: A		Page 1 of 1

## FIRST ARTICLE INSPECTION CHECKLIST

X First Article	Prototype
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Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject Metho	
23.25	+/-0.030	23.74	do	7 B	5(
19.75	+/-0.030	1975	<u>y</u> _	7	
17.75	+/-0.030	17,75	يز	T	
14.25	+/-0.030	14.25	بر	τ	
9.50	+/-0.030	9,50	4	7	
4.75	+/-0.030	4,75	A	7	
2.00	+/-0.030	800,6	*	7	
6.00	+/-0.030	6,00	*	7	
6.75	+/-0.030	6.75	<i>X</i> ₹	7	
0.30	+/-0.030	-310	K	v 180	37
0.30	+/-0.030	,35	70	V	
1.89	+/-0.030	1.875	æ	V	
Ø0.19	+0.005/-0.001	.195	*	V	
0.063	+/-0.010	-600.	×	V	
4.					

Measured by:	B	Audited by:	Prototype Approval:	N/A
Date:	10-11-16	Date: 10/11/16	Date:	N/A

Rev	Date	Change	Revised by	Approyed
Α	07.03.14	New Issue	KJ/JLM ox	
				7,007

Dait Ac	оориос							
W/O:			WO	RK ORDER CHANGE	ES _			
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DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section (		QC Inspector
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CHECKED

DRAWING NO.

SHEET 1 OF 6

SCALE 1:10

B

DART

AEROSPACE PORT HADLOCK, 1

NO.

06.10.

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GASKET

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06.10.

.25

NEW ISSUE

23.15 21.15 17.65 0.90 · 5.65 -1.89 3.90 DETAIL A 8.00 **#0.19** 14.00 (TYP 3 PLS)

D3536-11 GASKET

32.90
29.40
27.40
23.90
18.98 ———————————————————————————————————
DETAIL A 8.00 3.90

SHOP COPY

**RETURN TO ENGINEERING** 

**UNCONTROLLED COPY** SUBJECT TO AMENDMENT

WITHOUT NOTICE

WORK ORDER NO. 43579 BS 10-11-04

- 1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60 DUROMETER (REF DART SPEC. M-NEO60-S.083)
- FINISH: NONE
- PART IS SYMMETRICAL ABOUT &
- TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- ALL DIMENSIONS ARE IN INCHES
- IDENTIFY WITH DART P/N USING A WHITE FINE POINT PERMANENT INK MARKER
- 7) SEE PAGE 6 FOR DETAILS AND SECTION

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DETAIL A
(TYP 4 PLS) 14.00
D3536-13 GASKET

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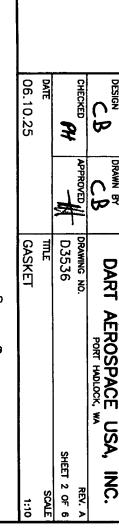
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W/O:			W	ORK ORDER CHANG	GES				•
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T	STEP	Description of NC			tion B		Verification	Approval	Approval
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D3536-15 GASKET



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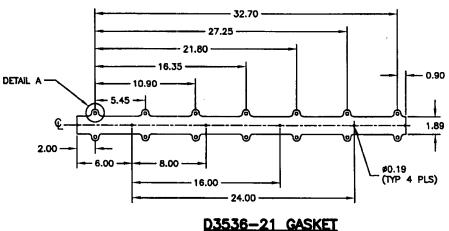
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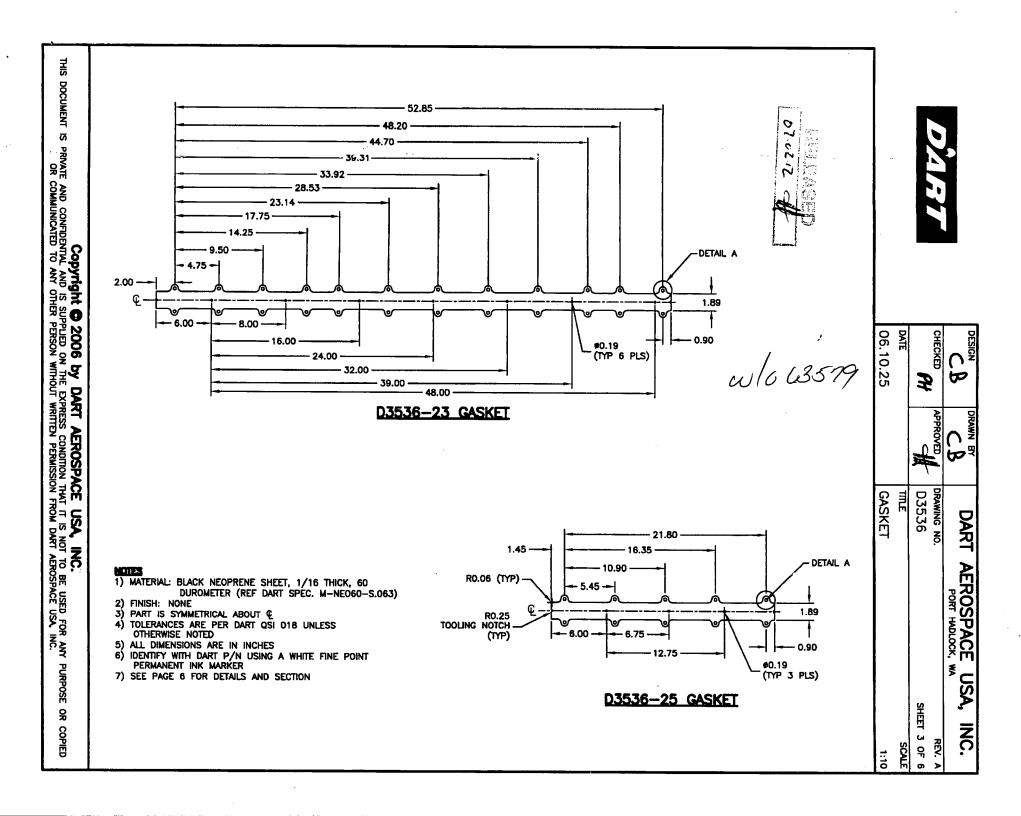
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  1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60
  DUROMETER (REF DART SPEC. M-NEO60-S.063)
- 2) FINISH: NONE 3) PART IS SYMM
- PART IS SYMMETRICAL ABOUT &
  TOLERANCES ARE PER DART QSI 018 UNLESS
  OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) IDENTIFY WITH DART P/N USING A WHITE FINE POINT PERMANENT INK MARKER
  7) SEE PAGE 6 FOR DETAILS AND SECTION



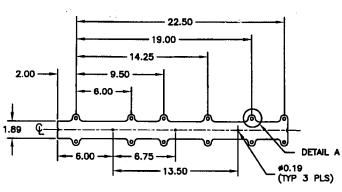
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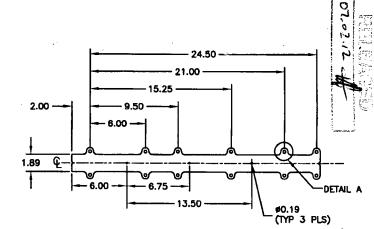
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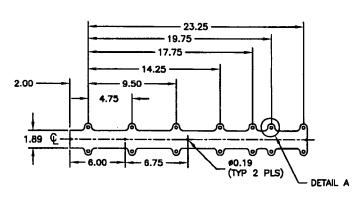
D3536-31 GASKET



D3536-33 GASKET

- 1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60 DUROMETER (REF DART SPEC. M-NEO60-S.063)

- DUROMETER (REF DART SPEC. M-NEOBO-S
  2) FINISH: NONE
  3) PART IS SYMMETRICAL ABOUT ©
  4) TOLERANCES ARE PER DART QSI 018 UNLESS
  OTHERWISE NOTED
  5) ALL DIMENSIONS ARE IN INCHES
  6) IDENTIFY WITH DART P/N USING A WHITE FINE POINT
  PERMANENT INK MARKER
- 7) SEE PAGE 6 FOR DETAILS AND SECTION



D3536-35 GASKET

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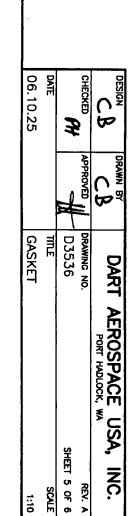
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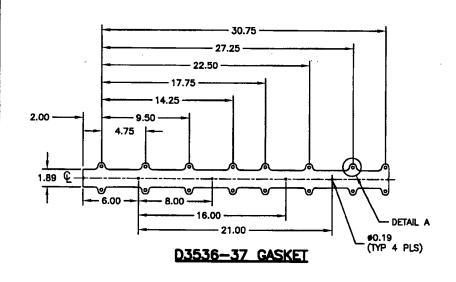
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1) MATERIAL:	BLACK NEG	OPRENE	SHEET,	1/16	THICK.	60
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2) FINISH: NONE

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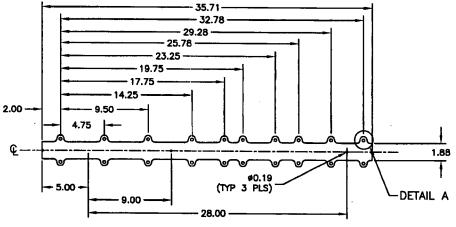
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3) PART IS SYMMETRICAL ABOUT ©
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ALL DIMENSIONS ARE IN INCHES
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7) SEE PAGE 6 FOR DETAILS AND SECTION

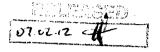


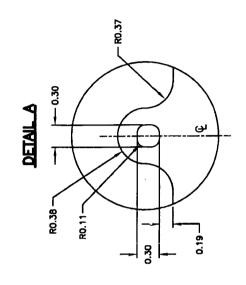
**D3536-39 GASKET** 

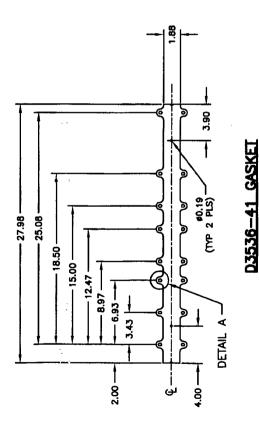
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	PH	#	D3536	SHEET 6 OF 6
Ì	DATE		TITLE	SCALE
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1) MATERIAL: BLACK NEOPRENE SHEET, 1/18 THICK, 60 DUROMETER (REF DART SPEC. M-NEO60-S.063) AL DIMENSIONS ARE IN: INCHES IDENTIFY WITH DART P/N USING A WHITE FINE POINT PERMANENT INK MARKER PART IS SYMMETRICAL ABOUT & TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED ରନ୍ଦ <u>@</u>

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DATE	STEP	PROCEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approva QC Inspector		
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